

CUSTOM TEXTURED

Work Order ID 124683

\*124683\*

September-22-14 9:42:22 AM

Page 1

Item ID: D3874-1L02 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Floor Protector, Co-Pilot (Black)  
 Start Date: 9/22/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/26/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan:                      Date:                      Tooling:                      Date:                      Run Start \*NR1\*  
 QC:                      Date:                      SPC (Y/N):                      Date:                      Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3874	B

100	0.00								
*100*									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								

SEP 22 2014

DAS  
24  
9-89

105	0.00								
*105*									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								

Dry Material

Temp: 245 deg. F

Time IN: 5:00 PM

Time OUT: 5:00 AM

SEP 23 2014

Per...                     

DAS  
07  
9-89

14/09/23

**\*124683\***

Page 2

**\*N900040100\***

**Setup**   **Start**   **\*NS1\***

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 9/22/14      **Start Qty:** 1.00

**\* 1 \***

**Customer:**

**Required Date:** 9/26/14      **Req'd Qty:** 1.00

**\*1\***

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_      **Run**      **Start**      **\*NR1\***  
                          **QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_      **Stop**      **\*NB2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							DAS

110

**\*110\***

### Thermoform

### Thermoforming Machine

## Memo

0.00

0.00

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA038 using tool DT9474  
Dwg Rev: B  
Folio Rev: A

**Visually inspect for proper formation and texture**

140

**\*140\***

HandThermo

### Hand Finishing Thermoforming

## Memo

0.00

0.00

1-Trim to finished dimensions as per Dwg

150

**\*150\***

OC

## Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

## Memo

0.00

Complete FAI document

**DAS  
07  
9-89**

**DAS  
07  
9-89**

14/09/2

**Work Order ID 124683****\*124683\***

Page 3

Item ID: D3874-1L02

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Protector, Co-Pilot (Black)

Start Date: 9/22/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

DAS

38

9-89

14-9-23

170 Identify as per dwg &amp; Stock Location: \_\_\_\_\_ 0.00

**\*170\***

Packaging

Memo

PPP124682 0.00

Packaging

DAS

32

-89

1.14/9/23

180 QC21- Final Inspection - Work Order Release 0.00

**\*180\***

QC

Memo

0.00

Quality Control

MLJ 14-09-24

14-9-23

# Picklist Print

September-22-14 9:42:22 AM

Page 1

Work Order ID: 124683

**\*124683\***

Parent Item: D3874-1L02

**\*D3874-1L02\***

Parent Item Name: Floor Protector, Co-Pilot (Black)

Start Date: 9/22/14

Required Date: 9/26/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A colors added to D3874-1 parts 14/07/02 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F6006-02

Purchased

No

100

sf

2,174.880

4.38

5

**DAS**

**07**

**9-89**

**\*MI FXS 125-F6006-02\***

GE PLASTICS LEXAN SHEET(BLACK)

**\*\***

Location

Loc Qty

Loc Code

MAT018

4.3

m128887

4.3

waterjet

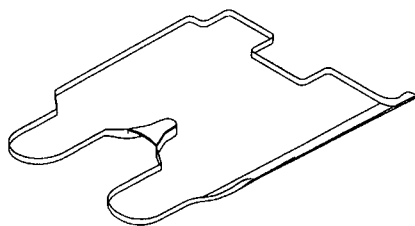
2170.58

m128887

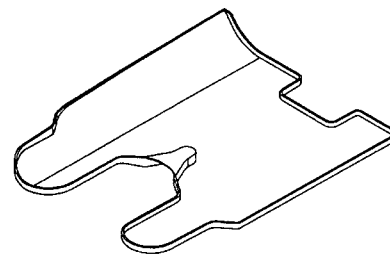
2170.58

14/07/23

5 8 21



**△ B D3874-1LXX FLOOR PROTECTOR**



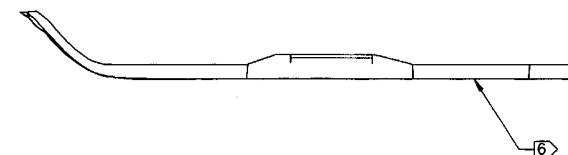
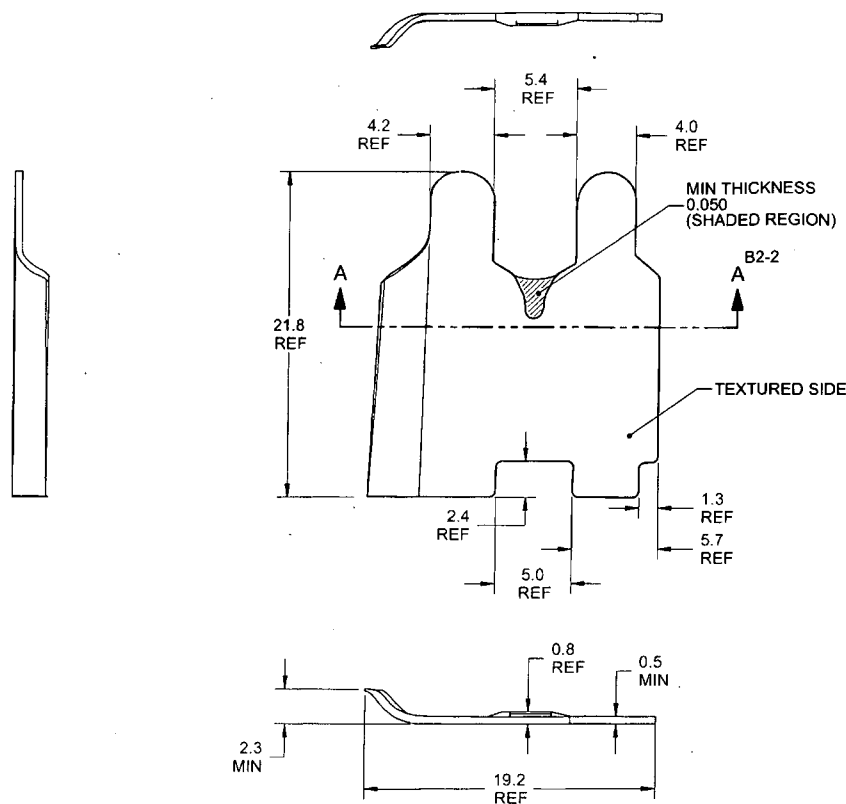
**△ B D3874-2LXX FLOOR PROTECTOR**

124683

**RELEASED**  
2014-06-17

B	ADDED D3874-1L02 AND D3874-2L02 CONFIGURATIONS AND RE-IDENTIFIED D3874-1 AND D3874-2, AS D3874-1L08 AND D3874-2L08. REVISED NOTE 1 AND ADDED MATERIAL TABLE.	AK	14.04.10
A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DL	<b>D3874</b>	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>FLOOR PROTECTOR</b>	NTS
DATE	14.04.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED



**SECTION A-A**  
SCALE 2X

**D3874-1LXX FLOOR PROTECTOR**

**RELEASED**  
2014-06-17

**NOTES:**

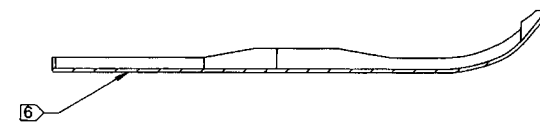
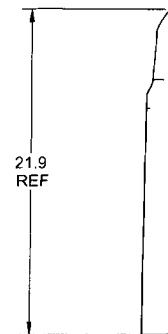
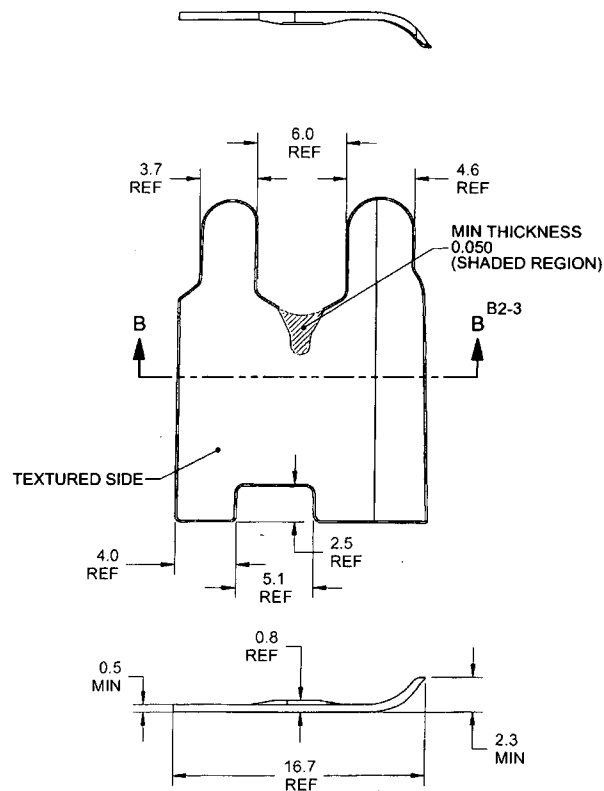
- 1) MATERIAL: SEE TABLE B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1LXX" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

**B**

PART NUMBER	DESCRIPTION
D3874-1L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEX.125-F6006-02)
D3874-1L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEX.118-90318-08)

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DESIGN	AK	<b>DART AEROSPACE LTD</b>	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DL	<b>D3874</b>	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>FLOOR PROTECTOR</b>	NTS
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SECTION B-B  
SCALE 2X

**D3874-2LXX FLOOR PROTECTOR**

**RELEASED**  
2014-06-17

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2LXX" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN



PART NUMBER	DESCRIPTION
D3874-2L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEX.125-F6006-02)
D3874-2L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEX.118-90318-08)

APPROVED

DESIGN	AK	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	DL	<b>D3874</b>	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>FLOOR PROTECTOR</b>	NTS
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DQA:

Date: 14/02/08



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/12/18

Work Order update only ☐

Work Order: <u>124603</u> Part No. <u>03874-1202</u> NCR No. <u>14-4363</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input checked="" type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input checked="" type="checkbox"/>	14/09/23	110	1	Add textured bottom as per customer requirements  Desi change.	DAS 12 9-89 14/9/23	OK. use as is per D.S. email	Dk. 14/09/23	S 14/10/02	S 14/10/02
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--	--

## Chris Provencal

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**From:** David Shepherd  
**Sent:** Friday, August 29, 2014 12:23 PM  
**To:** Peggy McDonald; Bill Beckett  
**Cc:** Sam Summers; Sian Willems; Nigel Forbes; Chris Provencal; Mike Petsche  
**Subject:** RE: BLACK textured floor protector - FYI

Peggy,

The part number will not be changing for this trial. So, if he's putting this into a 407, I believe the part number he needs is D407-781-025L02 per DSI 9695. If John is happy with it, we will need to decide whether the textured version becomes the standard or whether we create a separate part number. I know Bill is leaning towards making the textured version the standard.

Bill,

Agreed ... The textured version can be signed off as deviation by Chris Provencal or Mike Petsche. We need to ensure that the texture doesn't interfere with the installation.

Regards,  
David

---

**From:** Peggy McDonald  
**Sent:** August-29-14 10:03 AM  
**To:** Bill Beckett; David Shepherd  
**Cc:** Sam Summers; Sian Willems; Nigel Forbes  
**Subject:** RE: BLACK textured floor protector - FYI

We will need a P/N

---

**From:** Bill Beckett  
**Sent:** Friday, August 29, 2014 12:02 PM  
**To:** Peggy McDonald; David Shepherd  
**Cc:** Sam Summers; Sian Willems; Nigel Forbes  
**Subject:** Re: BLACK textured floor protector - FYI

Peggy - Great, can you get a an order in Intuitive and we will proceed.  
David - just sign off in a deviation?  
Bill

Sent from my iPhone

On Aug 29, 2014, at 11:56, "Peggy McDonald" <[pmcdonald@dartaero.com](mailto:pmcdonald@dartaero.com)> wrote:

Textured please. (forgot to include in the email)

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**From:** Bill Beckett  
**Sent:** Friday, August 29, 2014 11:55 AM  
**To:** Peggy McDonald